

Amendments to the Abstract:

Please replace the Abstract with the following amended Abstract:

ABSTRACT OF THE DISCLOSURE

~~In a continuous casting of steel~~[[,]] ~~the invention is able to accurately detect~~ A method for detecting a crater end ~~only from a value measured by a sensor without needing calibration based on the slab rivet method~~[[, etc.]] An of a continuously cast product including installing an ultrasonic shear wave sensor [[6, 8]] for transmitting an ultrasonic shear wave to a cast product [[1]] and receiving [[it]] the transmitted ultrasonic longitudinal wave and an ultrasonic longitudinal wave sensor [[7,9]] for transmitting an ultrasonic longitudinal wave to the case product and receiving ~~it are installed~~ the transmitted ultrasonic longitudinal wave at the same position in a continuous casting machine or at [[two]] positions apart from each other in a casting direction, but at the same position in a transverse direction of the cast product[[. From]], detecting based on variations of an ultrasonic signal received by the ultrasonic shear wave sensor[[,]] ~~it is detected that~~ [[a]] the crater end [[4]] of the cast product is matched with the installed position of the ultrasonic shear wave sensor[[. A]] , calibrating a calculation formula for determining the crater end ~~from a propagation time of an ultrasonic longitudinal wave signal is calibrated such that the crater end computed from the propagation time of the ultrasonic longitudinal wave signal at that time is matched with the installed position of the ultrasonic shear wave sensor~~[[.]] ~~After the calibration~~[[,]] and determining the crater end ~~is determined from the propagation time of the ultrasonic longitudinal wave signal based on the calibrated calculation formula.~~